120

QC

Quality Control

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Memo

0.00

1B11-3-3

M 11 03 03

Page 1

Insp.

Stamp

W/O:			W	ORK ORDER CHANG	GES					, ,
DATE	STEP	PRO	OCEDURE CH	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	Fault Cate	egory:	NCR:	Yes I	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposition	on:	QA: I	VC CIC	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR	)			
DATE	STEP	Description of NC	for this at		ction B	Sign &		ation	Approval	Approval
	0	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
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### Work Order ID 66928

Thursday, March 03, 2011 7:40:05 AM



Page 2

Item ID:

D3319-1

Accept



Setup Start



Revision ID:

Item Name:

Wearplate

**Start Date:** 

3/3/2011

Start Qty: 8.00

**Required Date: 3/11/2011** 

Req'd Qty: 8.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date:

Date:\_\_\_\_\_

Tooling:

SPC (Y/N):

Date: Date:

Tool # Plan

Code

Run

Start

Reject

Qty

Stop

Stop

Reject



Number Stamp

Insp.

Sequence ID/ **Work Center ID** 

140

Brake NC

Brake NC

Operation

NC BRAKE

Set Up/ Description

**Run Hours** 

0.00

0.00

1- Form using DT8326 & DT8261 as per Dwg D3319Rev:

2- Form flat on press using DT8776 block

SB 11/03/08

Accept

Qty

150

Quality Control -

QC6- Inspect dimensions to drawing

Memo

Memo

0.00

Suloz log

160

Large Fab Large Fab

Memo

Large Fab

0.00

0.00

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

1116772

2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev

A/R N/A

Weld per dwg A/R Hardcoat steel Batch:

Qty Part Number Description

Batch 228/7560 Hardcoat Rod

EL 11-3-14.



	- oppass									
W/O:			WO	RK ORDER CHANG	GES					1
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCF	: Yes I	10 <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:	Disposition	1:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	R NON-CONFORM	ANCE	(NCR	)			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector
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### Work Order ID 66928

Thursday, March 03, 2011 7:40:05 AM



Page 3

Item ID:

D3319-1

Accept

Setup Start



**Revision ID:** 

Item Name:

Wearplate

**Start Date:** 

Required Date: 3/11/2011

3/3/2011

Start Qty: 8.00

Req'd Qty: 8.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

QC:

Process Plan:

Date:

Memo

Memo

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/ **Work Center ID** 

170

QC

Quality Control

Operation Description

QC10- Inspect visual per OSI004- ground welds

Set Up/

Run Hours

0.00

8 1105/14

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

180

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Ju 103/14

190

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

**OVEN TEMPERATUR** FINISH TIME:

0.00

0.00

KR 11-3-15.

Dart Aerospace Ltd	D	art	Aer	osp	ace	Ltd
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### Work Order ID 66928

Thursday, March 03, 2011 7:40:05 AM



Page 4

Item ID:

D3319-1

Accept

Setup Start

Ston



Revision ID:

Item Name:

Wearplate

3/3/2011

**Start Date:** 

Start Oty: 8.00

Required Date: 3/11/2011

Req'd Oty: 8.00



**Cust Item ID:** 

**Customer:** 

Reference:

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A	nn	ro	va	le	•

Process Plan:

Date: Date:

Tooling:

Date: Date: Run

Start

Stop



Sequence ID/

**Work Center ID** 

2.00

**Ouality Control** 

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

SPC (Y/N):

0.00

0.00

Tool ID

Tool # Plan Code

Accept Otv

Reject Otv

Reject Number

Insp. Stamp

11/3/16 1/ (9.)

210

Packaging Packaging

Packaging

Memo

0.00

0.00

Identify on inside surface using a permanent fine point marker with the

following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1 B/N: BXXXXX For Product Eligibility see PDA05-18

and Stock Location: 797

220

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

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W/O: DATE STEP			W	ORK ORDER CHANG	GES				·	e.
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		on C	Chief Eng	QC Inspector

# Picklist Print

Thursday, March 03, 2011 7:40:11 AM

Work Order ID: 66928

Parent Item:

D3319-1

Parent Item Name: Wearplate



Start Date: 3/3/2011

Required Date: 3/11/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: B $\square$ 05.10.14 $\square$ Added step 9, dwg rev B  $\square$ KJ/EC $\square$  IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA	1881 187111 BBBN 181 1881	Purchased	No			100	sf	124.0000	0.628	5.288421	G ,		
										18	11-3-3		

1010/1025 SHEET .048

<b>Location</b>	Loc Qty	Loc Code		S
MAT	124			19
110996	4			
116268	120		82C011	

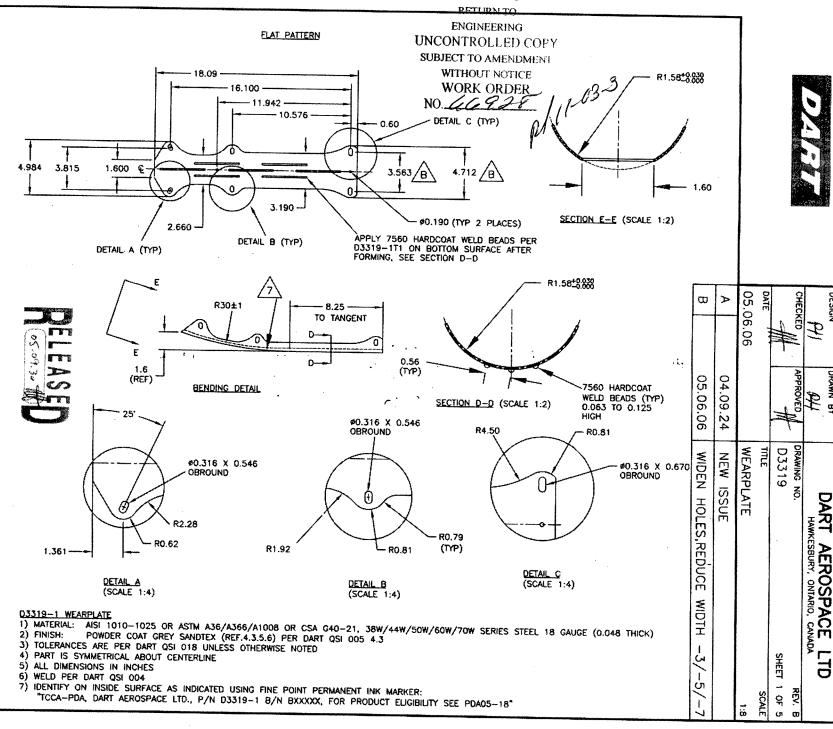
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DART AEROSPACE LTD	Work Order:	64928
Description: Wearplate	Part Number:	D3319-1
Inspection Dwg: D3319 Rev: B		Page 1 of 1

	FIRST ARTIC	LE INSPEC	TION CH	ECKLIS	ST ·	
	X First	Article	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.979	4		V1802	
1.600	+/-0.010	1,603	×		ν	
2.660	+/-0.010	2,466	4		ν	
3.190	+/-0.010	3,196	y		V	
3.563	+/-0.010	3,564	A		V	
4.712	+/-0.010	4.710	Y		V	
0.60	+/-0.030	103	<b>b</b>		V	
10.576	+/-0.010	10.576	8		T 1301	
11.942	+/-0.010	11,942	×		7	
18.09	+/-0.030	18.04	7		7	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	3192550			ý	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	394,676	I I		V	
Ø0.190	+0.005/-0.001	,194	<u>بر</u>		V	
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Date:	11-3-3	ate: //-03	-03		Date:	N/A

Rev	Date	Change	Revised by	Approv <i>e</i> d
Α	07.05.31	New Issue	KJ/JLM	

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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector

**APPLY 7560** FLAT PATTERN **HARDCOAT** WELD BEADS 75.52 PER D3319-3T1 ON BOTTOM 74.420 SURFACE AFTER FORMING, SEE 52.890 SECTION H-H 30.790 -8.690 2.690 0.60 -/B\ 4.518 5.063 6.163 2.940 -3.527 2.940 Ø0.190 /B\ 05.06 DETAIL F (TYP) (TYP 4 PLACES) DETAIL E (TYP) 2.690 -DETAIL J (TYP) 90 B DETAIL G (TYP) 2.940 wlu 11-03-3 H-WEARPLATE BENDING DETAIL D3319-3 WEARPLATE 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) PART IS SYMMETRICAL ABOUT CENTERLINE 5) ALL DIMENSIONS IN INCHES 6) WELD PER DART QSI 004 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA. DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX.

DRAWING NO.

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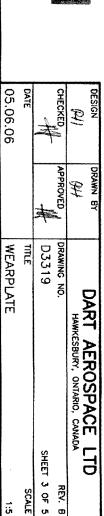
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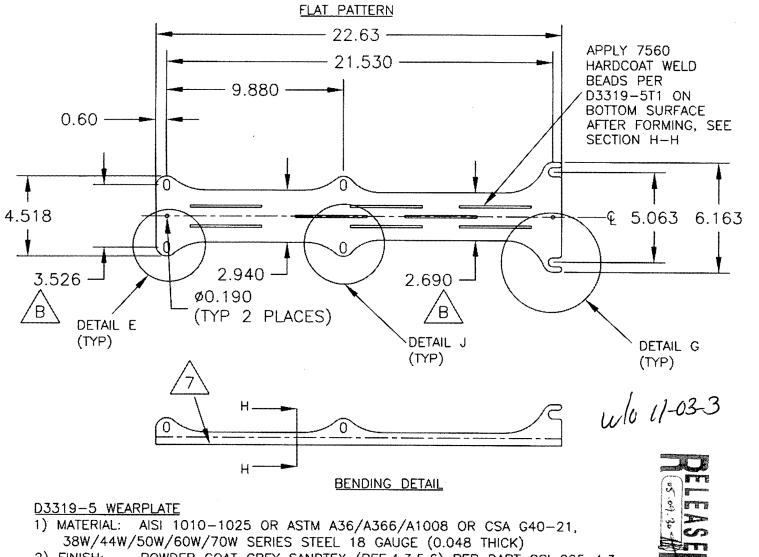
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FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES 6) WELD PER DART QSI 004

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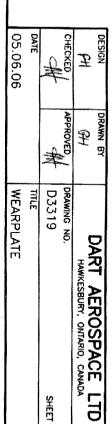
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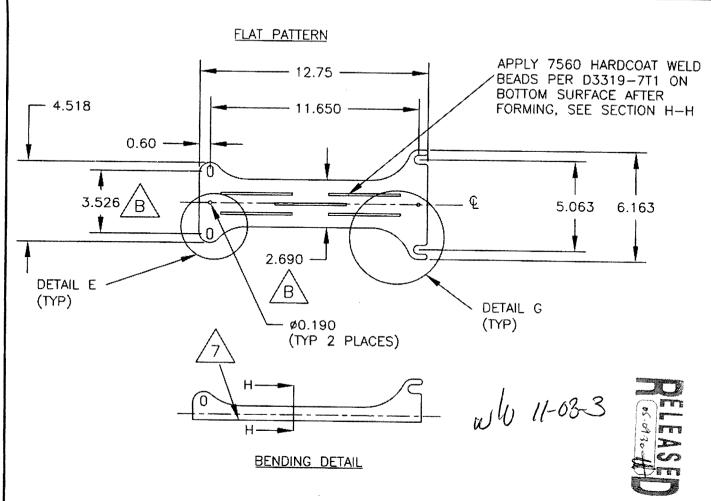
7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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### D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 2) FINISH:
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX. FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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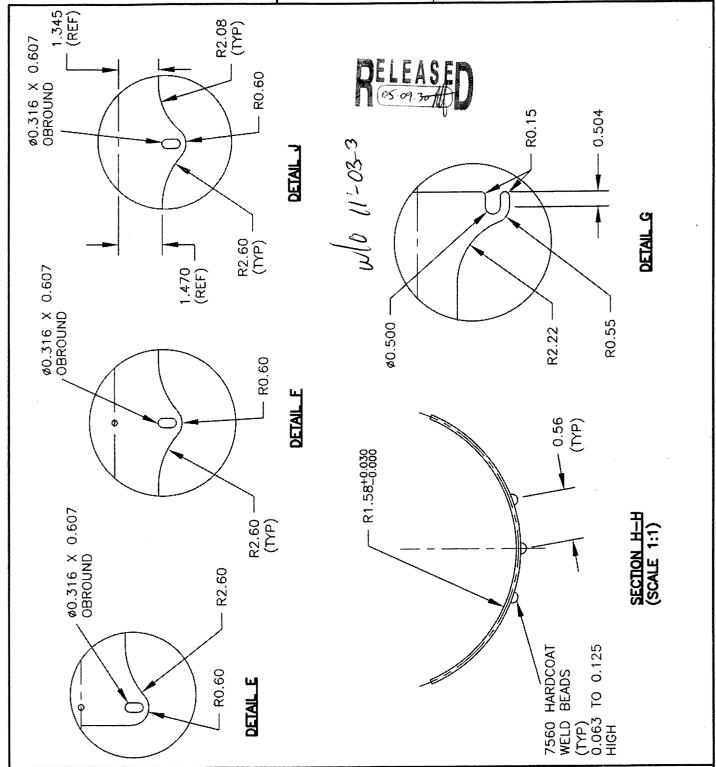
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# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC Inspector Approval Chief Eng / Prod Mgr QC Inspector Approval QC Inspector

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	_ Date:	
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